

54401 Deriv

## Work Order ID 53882



Page 1

November 23, 2009 11:21:49 AM

Item ID: D3065-5

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Leg

Start Date: 23/11/2009 Start Qty: 80.00



Cust Item ID:

Required Date: 27/11/2009 Req'd Qty: 80.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: PLDate: 07/12/09

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3065

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D  
necessary☐ Dwg Rev: B☐ Prog Rev: B☐ 2-Debur if6561  
.086

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 9-12-3

(88)

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

2) 8 or 12/04  
QSP0196561  
(X88)

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 53882

November 23, 2009 11:21:49 AM



Page 2

Item ID: D3065-5

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Leg

Start Date: 23/11/2009 Start Qty: 80.00



Cust Item ID:

Required Date: 27/11/2009 Req'd Qty: 80.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

*BR 09-12-7*



HandFinish

Memo

0.00

Hand Finishing

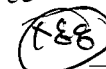
140

QC3- Inspect Part Finish

0.00

*2) 5 or 12/08*

*counted*



*[Signature]*



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

*[Signature]* *(88)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 53882**

November 23, 2009 11:21:49 AM



Page 3

Item ID: D3065-5

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Leg

Start Date: 23/11/2009 Start Qty: 80.00



Cust Item ID:

Required Date: 27/11/2009 Req'd Qty: 80.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/08  
MF  
09-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November 23, 2009 11:21:55 AM

Page 1

Work Order ID: 53882

Parent Item: D3065-5RevB

Parent Item Name: Step Leg

Comments:

Start Date: 23/11/2009

Required Date: 27/11/2009

Start Qty: 80.00

Required Qty: 80.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M6061T6S.080

Purchased

No

100

sf

161.3809

90.9305

100.0508



6061-T6 .080 Sheet

B 9 12-3

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

161.38087

107904

0.02

110254

1.5

110630

33.5136

112040

0.0437

112141

9

112512

0.2784

112763

117.02517

$$\begin{aligned} 107904 \times 1 &= 1.1366 \\ 110254 \times 1 &= \end{aligned}$$

$$\begin{aligned} 112040 \times 1 &= \\ 112141 \times 1 &= \\ 112512 \times 1 &= \\ 112763 \times 83 &= 94.3403 \end{aligned}$$

82.02517

2784

9.

0.0437

1.500

0.0200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



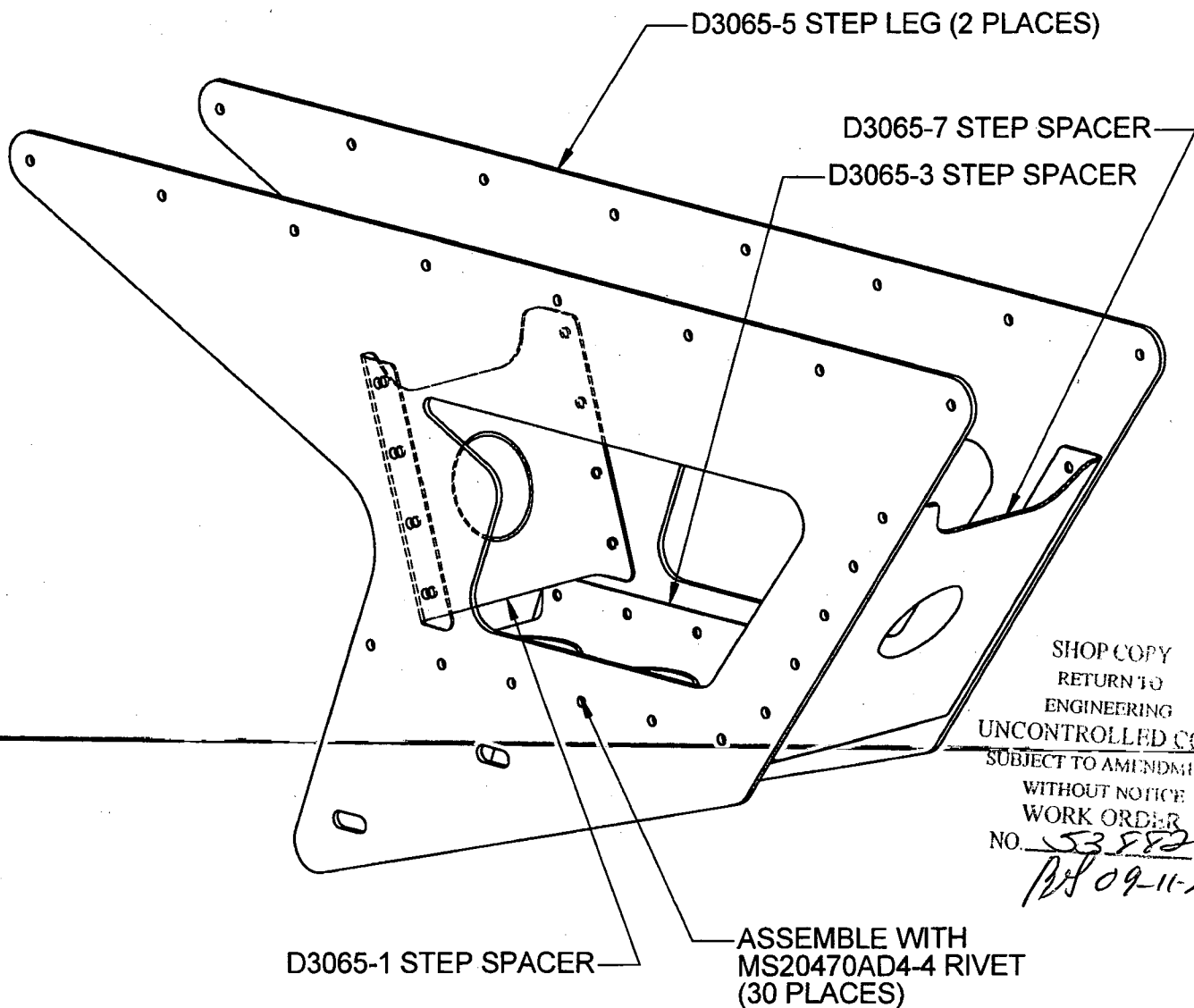




DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



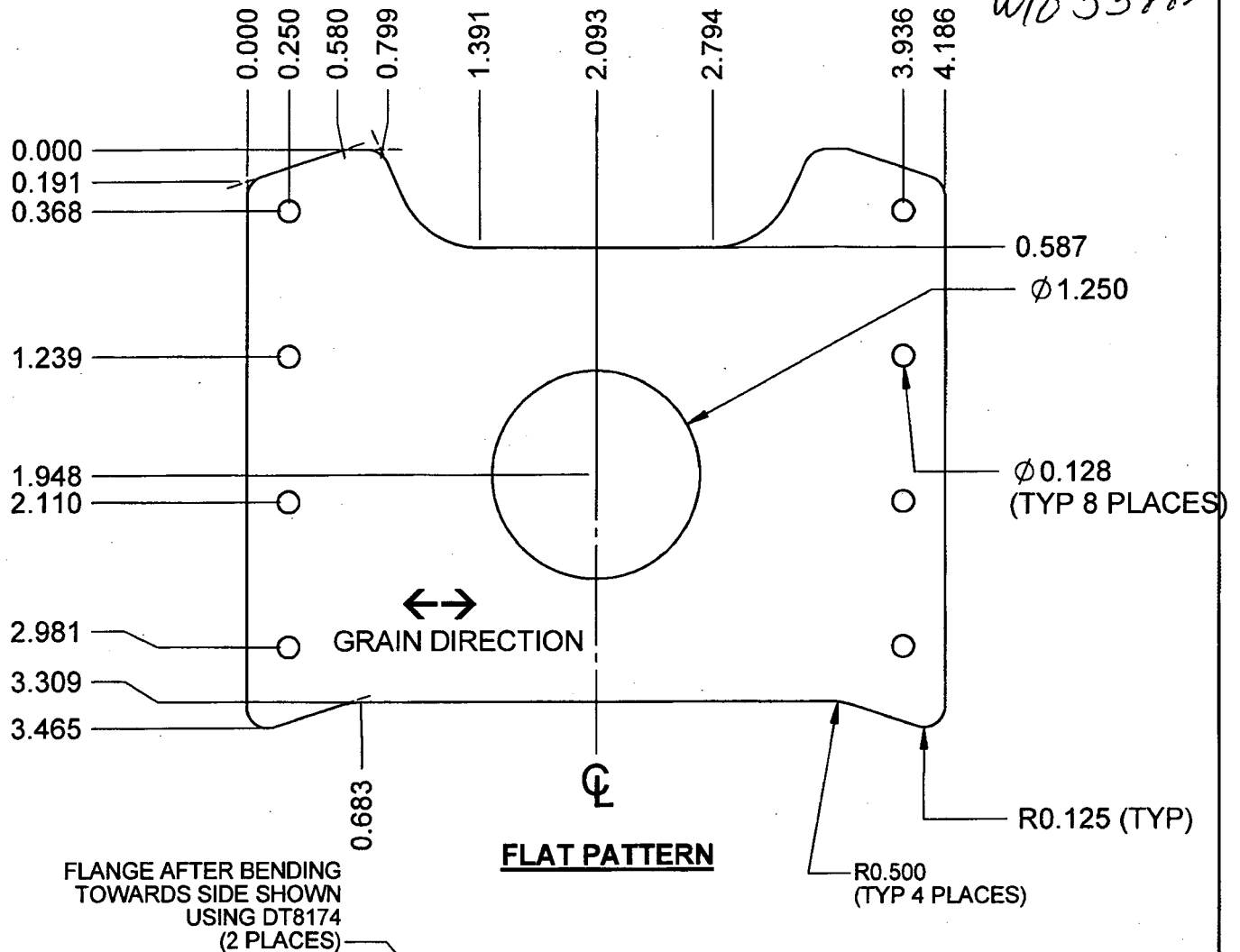
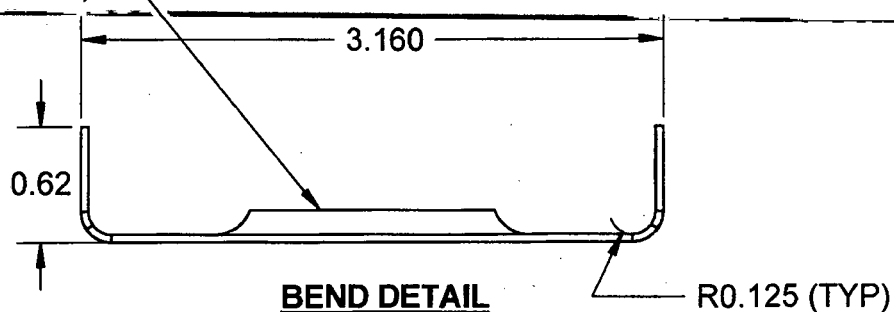
## D3065-041 STEP LEG ASSEMBLY

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 2 OF 5
DATE <b>06.05.23</b>	TITLE <b>STEP LEG ASSEMBLY</b>		SCALE 1:1

**RELEASED***cl. de-20***D3065-1 STEP SPACER**

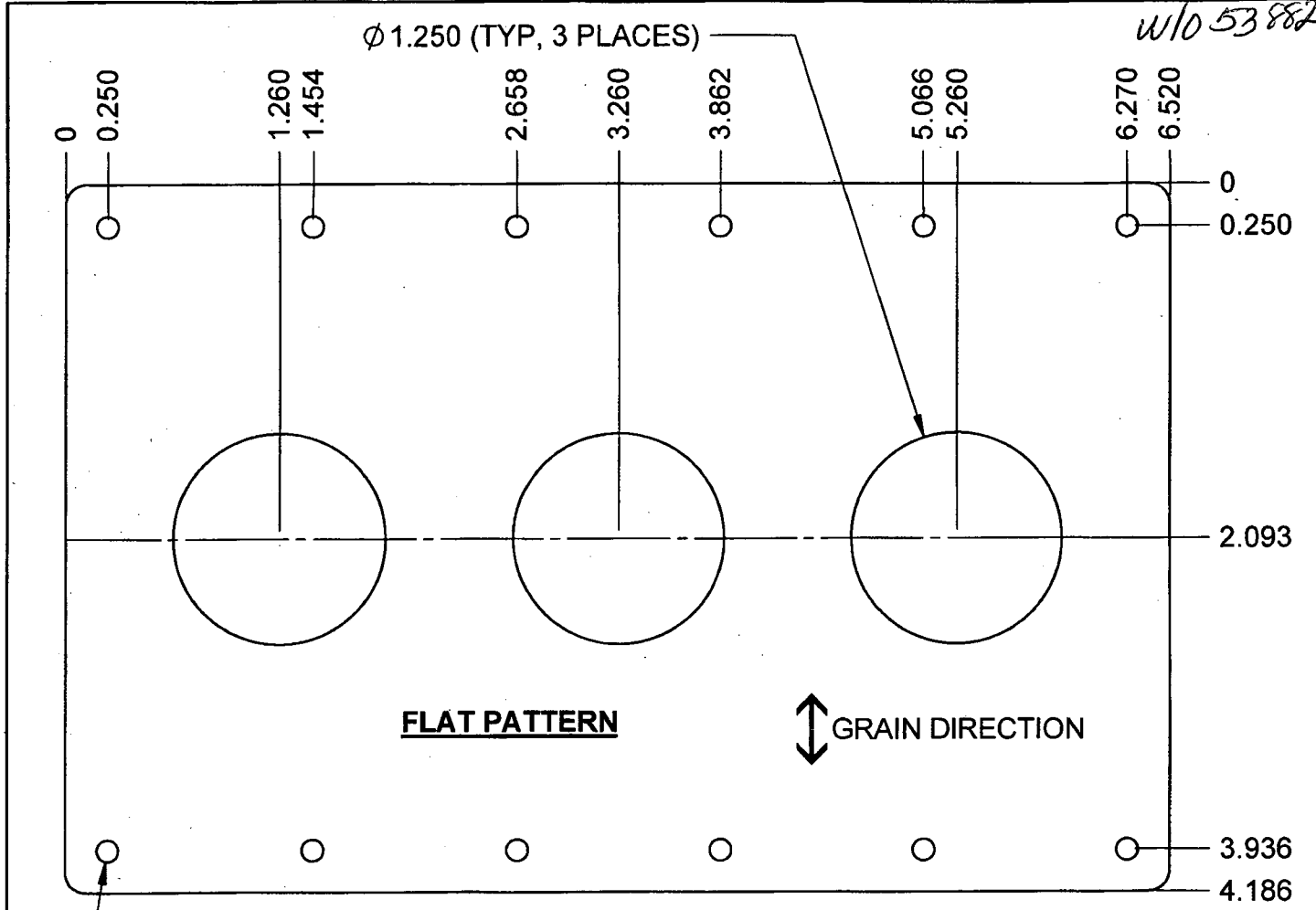
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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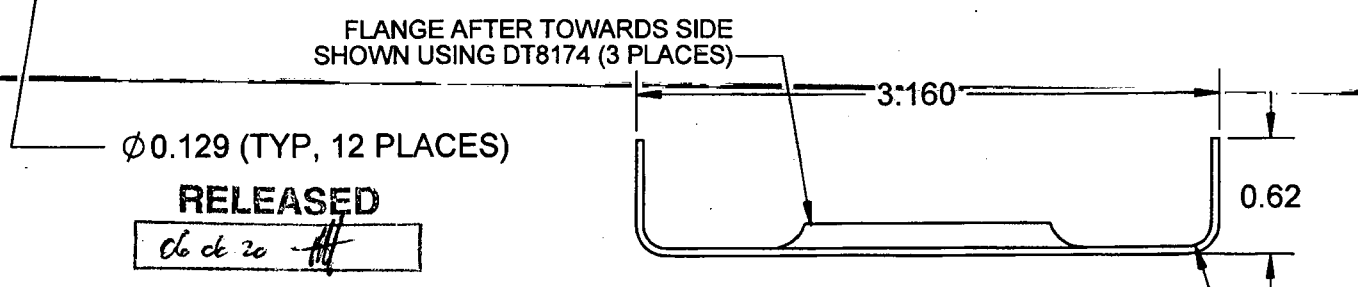
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DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1



*W/0 53882*



**D3065-3 STEP SPACER**

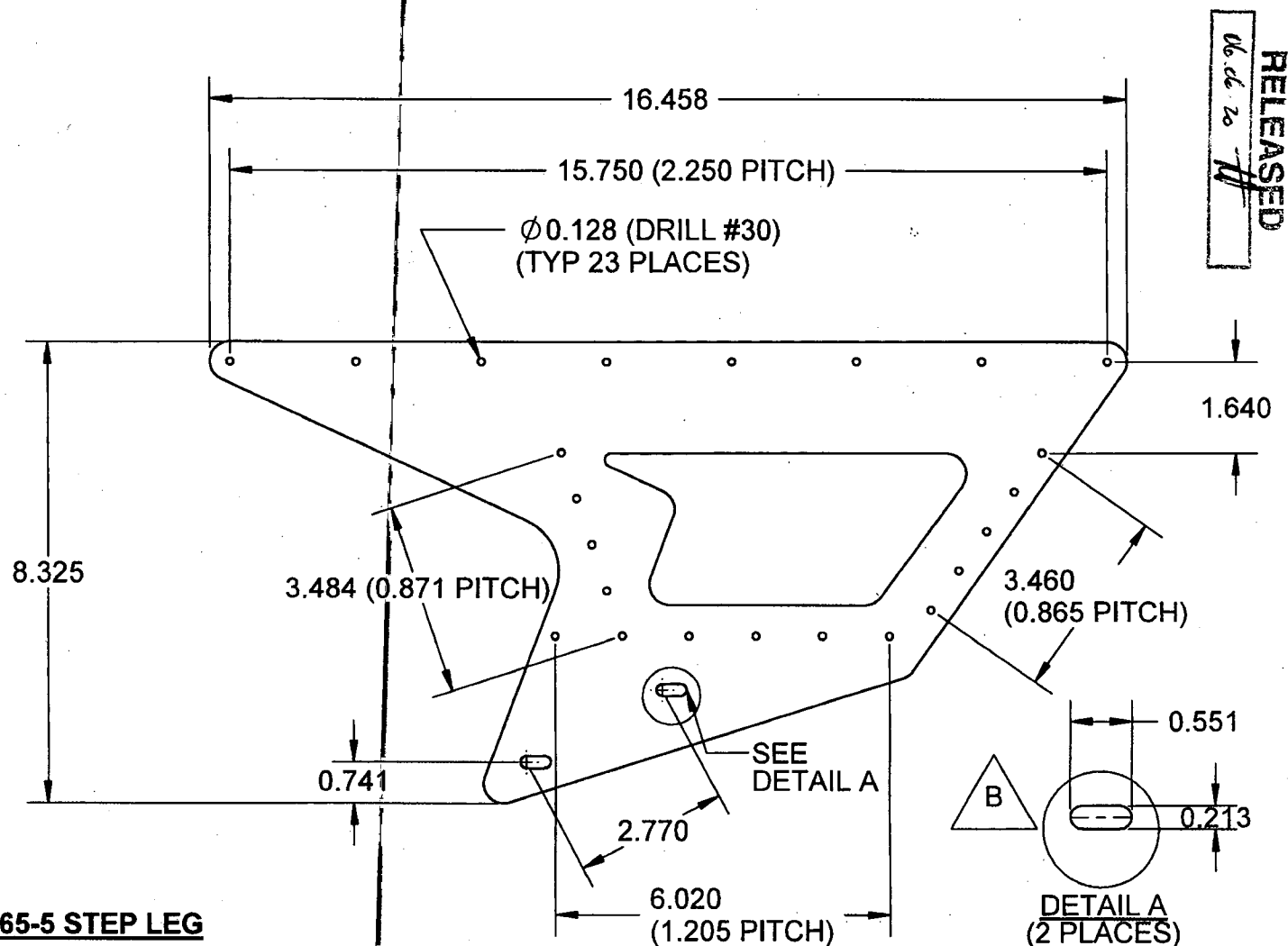
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
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CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. B
06.05.23	D3065	SHEET 4 OF 5
	STEP LEG ASSEMBLY	SCALE 1:3



**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRJT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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